

Work Order ID 140641

January 12, 2016 1:45:43 PM

140641

To ship + stock
26/01

Page 1

Item ID: D412-698-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Support - V Block

Start Date: 1/12/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/22/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160112

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-015 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS 1601-18

6

DAS
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9-89

JAN 26 2016

JAN 18 2016

DAS
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27
9-89

6

DAS
28
9-89

JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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Item ID: D412-698-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Support - V Block

Start Date: 1/12/2016 Start Qty: 6.00

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Cust Item ID:

Required Date: 1/22/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPF D412-698-015 Location:FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 140641

140641

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 1/12/2016

Required Date: 1/22/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3200-1 6 *D3200-1* Door Post Block		Manufactured	No			110	Each	12.0000	2	12			
				<u>Location</u>				<u>Loc Qty</u>					
				ST022	131137			12					
								12					
D3200-3 6 *D3200-3* Door Wedge		Manufactured	No			110	Each	4.0000	2	12			
				<u>Location</u>				<u>Loc Qty</u>					
				ST023	129898			4					
								4					
D3201-1 6 *D3201-1* Doubler		Manufactured	No			110	Each	3.0000	2	12			
				<u>Location</u>				<u>Loc Qty</u>					
				ST023	133159			3					
								3					
D3201-3 6 *D3201-3* Angle		Manufactured	No			110	Each	2.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>					
				ST023	131034			2					
								2					

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Work Order ID: 140641

Parent Item: D412-698-015

Parent Item Name: Door Support - V Block

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D412-698-015

Start Date: 1/12/2016

Required Date: 1/22/2016

Start Qty: 6.00

Required Qty: 6.00

D3201-4

Manufactured No

110 Each

3.0000

1 6

D3201-4

Angle

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** 3x β 139 570

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Location

Loc Qty

Loc Code

ST023

3

129904

3

3

MS21042L3

Purchased No

110 Each

1,135.000

12

72

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

212

m133790

212

ST304

760

m133790

760

72

MS24693-S277

Purchased No

110 Each

112.0000

12

72

MS24693-S277

Screw

**

Location

Loc Qty

Loc Code

ST286

112

131677

12

M133790

100

24
48

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Work Order ID: 140641

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Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 1/12/2016

Required Date: 1/22/2016

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0332J

Purchased

No

110

Each

1,223.000

12

72

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

70

m129682

70

GA

281

m132677

281

ST264

858

m133498

858

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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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